

Date: Thursday, 3/23/2006 3:52:14 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 26367					
Estimate Number	: 10764					
P.O. Number	: N/A			Part Number	: D2876	
This Issue	: 3/23/2006		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Number	: D2876 REV A	
First Issue	: 3/23/2006		Type	: MACHINED PARTS		
Previous Run	: 24851			Project Number	: N/A	
Written By	: See Comment Below			Drawing Revision	: A	
Checked & Approved By	: JF 06.03.24			Material	: NOTE:1 BLANK MAKES 4 PARTS	
Comment	: Esr Rev:B 00.03.19 Added inspect level 8 EC			Due Date	: 4/20/2006	
					Qty:	120
					Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S100	5052-H32 .100 Sheet
		Comment: Qty.: 0.0542 sf(s)/Unit Total : 6.5016 sf(s) Material: 5052-H32/H34 (QQ-A-250/8) 0.100" Thick Batch: M15530
2.0	SHEAR	SHEAR
		Comment: SHEAR 1 blank makes 4 parts Blank: 7.00" x 4.25" (+0.030" - 0.000")
3.0	HAAS Water Set	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 <i>Cut per Day D2876</i> <i>Dwg: Rev A</i> <i>1 Machine per folio D2876</i> <i>Prog: Rev A</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>E/100 06.05.01</i> <i>(20)</i>
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>JL 06/05/05</i> <i>20.05.06</i> <i>120</i>

NOTE: HFEDORMIS Quality Assurance Department

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

Date: Thursday, 3/23/2006 3:52:14 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 26367

Part Number: D2876

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SAN 06:05:09

126

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

PL oct/05/11 58

Chemical Conversion Coat as per QSI 005 4.1

MF - 06.05.10 62

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/05/11

06/05/11

120

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S2 392

PL 06/05/11 120

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PL 06/05/11 120

120

Job Completion



PL 06/05/11 120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26367
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

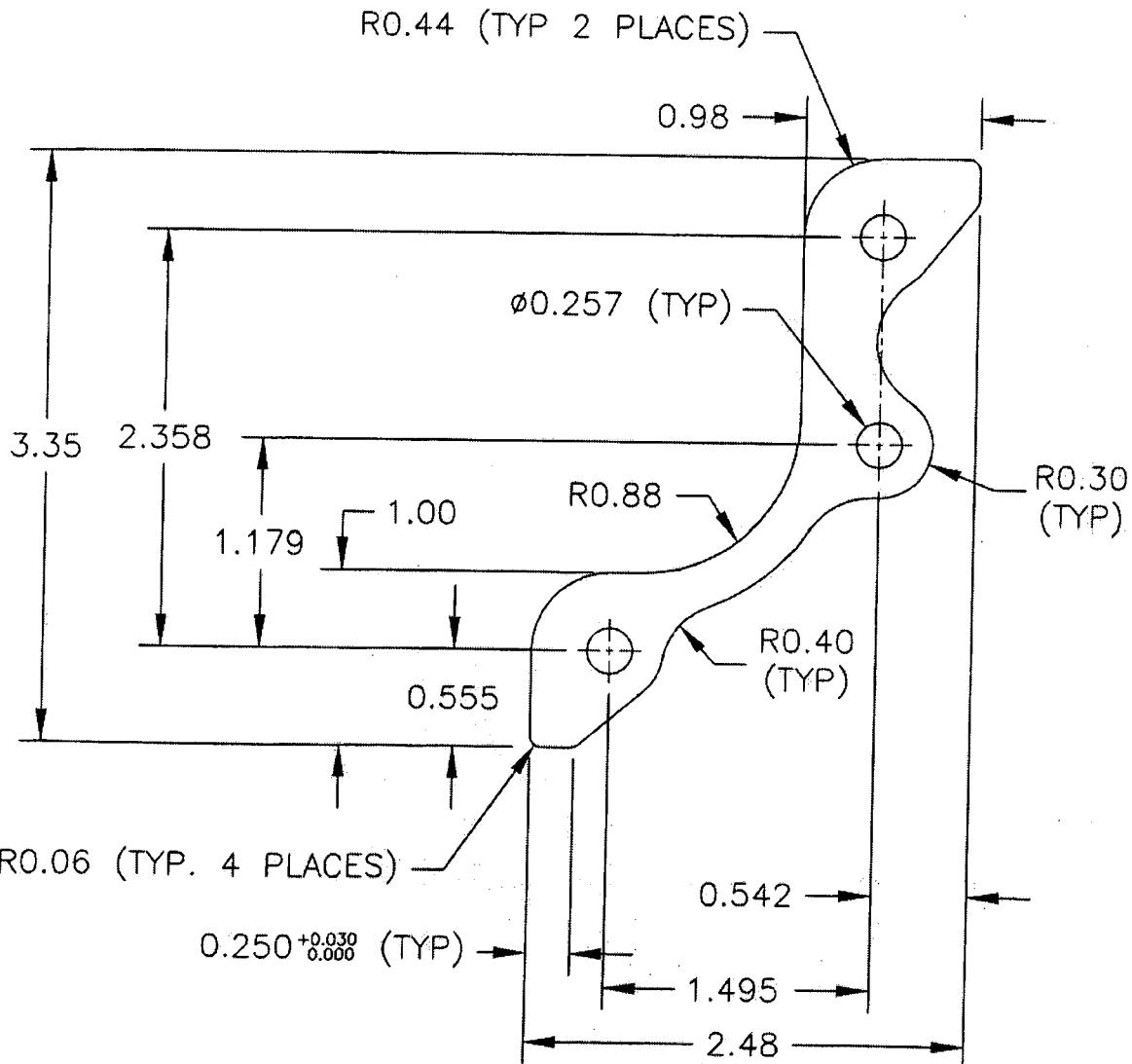
Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	06.05.01	Date:	06.05.06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.15	Removed 0.250 dimension	KJ/JLM	<i>[Signature]</i>



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	S	DRAWING NO. D2876
DATE	99.02.23			REV. A SHEET 1 OF 1
				TITLE SCALE 1:1
A	99.02.23			NEW ISSUE

RELEASED
99.04.27 DS



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 26367